

Date: Wednesday, 2/15/2006 3:46:49 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE
Job Number	: 25845		
Estimate Number	: 10866		
P.O. Number	: N/A	Part Number	: D31821
This Issue	: 2/15/2006 S.O. No. : N/A	Drawing Number	: D3182 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 25240	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/2/2006
Checked & Approved By	: <u>06.02.16</u>	Qty:	20 Um: Each
Comment	: Est A 03.01.29 New issue KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 603

Email or ship DXF file to vendor

Laser Cut D3182-1 per Dwg D3182

Material release note required

u 06.02.16 20

2.0

D31821F

Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Hinge

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

C 06/03/09 (20)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D3182-1T1

SB 06/03/09 (20)

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1




Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary

SAD 06.03.12 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:49 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 25845

Part Number: D31821

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SB 06/03/13

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/03/14 (20)

Job Completion



u 0603-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

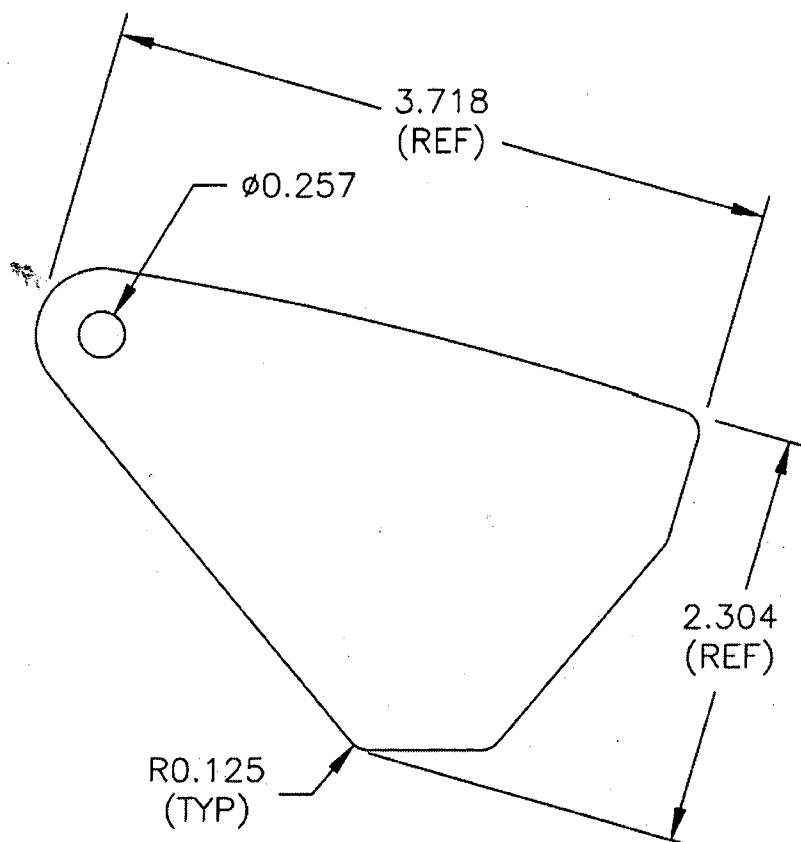
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3182	REV. A SHEET 1 OF 1
DATE 03.01.21		TITLE HINGE	SCALE 1:1
A	03.01.21	NEW ISSUE	

RELEASED  
03.01.21 [Signature]



#### D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK  
(REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25845

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P57020PC002

OCT-20-2005 15:06 OLBERT METAL SALES  
**OLBERT METAL SALES LIMITED**  
**WILKINSON STEEL AND METALS** PO/RS P51020PC002V  
 STAINLESS COIL 304  
 11 GA (11.4 x 11.9) X 48.0000"  
 PART NO.

985 795 1320 P.02/2  
 BL VA-000504-001 20Oct05  
 Pg 1/1



Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,  
 Paragraph 4.3 by TÜV Aufgetechnik GmbH (Notified Body Identification No.0035)  
 Inspection Certificate EN10204-3.1B

Shanxi Taigang Stainless Steel CO.,LTD Member of Taiyuan Iron and Steel (Group) Co.,LTD				MILL TEST CERTIFICATE							
NO.2 Jiansheping, Taiyuan, Shanxi, P.R.China TEL: (0351)3013328 FAX: (0351)3017816 http://www.tisco.com.cn E-mail: tgbxg@tisco.com.cn				MATERIAL: AISI304 No.2B Finish							
				SPECIFICATION: ASTM A240/A480		ASME-SA240/SA480					
				L/C NO.							
				CERTIFICATE NO. 20030636							
				DATE OF ISSUE 11							
CUSTOMER: OLBERT				CONTRACT NO. 1149		DATE OF 2003/06/20					
Product		Molding furnace		Inspector's stamp		Mark of the Manufacturer					
COIL		E+VOD				Shanxi Taiyuan Stainless Steel Co.,Ltd					
NO.	Heat No.	Coil No.	Quantity	Dimensions			Weight (kg)				
8	QBPI133	5A4-278-4ZB	1	20GA x 48 x C			8528				
9	Y501898	5A4-419-4ZY	1	14GA x 48 x C			5396				
10	4501977	5A4-348-12B	1	11GA x 48 x C			5182				
11	4501969	5A4-416-4ZY	1	14GA x 48 x C			7709				
12	4501968	5A4-415-4ZY	1	14GA x 48 x C			7495				
13	4501965	5A4-367-1ZB	1	11GA x 48 x C			8127				
14	4500491	5A5-18-4ZJ	1	20GA x 48 x C			7868				
Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
QBPI133	0.049	0.470	1.090	0.023	0.003	18.340	8.050				0.039
Y501898	0.038	0.430	1.000	0.029	0.004	18.420	8.070				0.066
4501977	0.070	0.470	1.310	0.019	0.002	18.050	8.100				0.050
4501969	0.030	0.430	1.270	0.018	0.002	18.020	8.010				0.050
4501968	0.060	0.460	1.350	0.018	0.003	18.120	8.100				0.050
4501965	0.050	0.440	1.320	0.019	0.002	18.140	8.090				0.050
4500491	0.050	0.500	1.340	0.020	0.002	18.040	8.060				0.050
Mechanical Properties								Hardness			
Test No.	Tensile R <sub>m</sub> N/mm <sup>2</sup>	R <sub>0.2</sub> Yield <sub>0.2%</sub> N/mm <sup>2</sup>	R <sub>m0.01</sub> Yield <sub>0.01%</sub> N/mm <sup>2</sup>	Elongation A5%	Corrosion Years	HRB			HV		HRC
QBPI133-T	670	290		55					175		
Y501898-T	665	289		60		83					
4501977-T	635	279		60		86					
4501969-T	655	298		61		84					
4501968-T	650	294		58		84					
4501965-T	650	283		60		85					
4500491-T	660	329		60					172		
Surface and dimensions controlled: O.K.											
Work inspection 26.10.05											

Page: 2 of 3

Doc No. 1201 - Inspected 18A and 18B by email

TOTAL P.02